

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009328**Date Inspected:** 24-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming, Guo Peng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY #14

This QA Inspector randomly observed the following work in progress.

SMAW welding process of weld joint 007 located on PCMK SEG063*. Welder is identified as 215587 ZPMC QC is identified as Xin Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2211-B-U2-FCM-1.

BAY #10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 16 located on PCMK NSD1-FDSA4-3C/D. Welder is identified as 050041 ZPMC QC is identified as Du Zhigun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 3A located on PCMK SSTL4-1B/L. Welder is identified as 053869 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2232-C-U2-F.

FCAW welding process of weld joint 4B located on PCMK SSTL4-1B/L. Welder is identified as 040533 ZPMC QC is identified as Shi Jiang Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U4-F.

BAY #11

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 80 located on PCMK WSTL3-4B/K. Welder is identified as 049220 ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-P4-F.

FCAW welding process of weld joint 27 located on PCMK WSTL3-4K/K. Welder is identified as 058792ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F.

OUTSIDE YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 8BE

FCAW welding process of weld joint 047 located on PCMK SSD19-PP65. Welder is identified as 055564 ZPMC QC is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

OBG SEGMENT 7DE

SMAW welding process of weld joint 021 located on PCMK SEG949D. Welder is identified as 216086 ZPMC QC is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-4213-TC-U4B-2.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

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Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer